

ship Nov 3

Work Order ID 152658

\*152658\*

Page 1

Thursday, November 03, 2016 10:48:44 AM

Item ID: D5470-1 **POSITIVE RECALL** **PRELIMINARY ISSUE** **Accept** \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM **RELEASED** Stop \*NS2\*  
 Item Name: Spacepod Floor Shim *Rev A 5/16/11/08*  
 Start Date: 11/3/2016 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 11/3/2016 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: *Qm* Date: *16/11/3* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp     |
|--------------------------------|---------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                                           |                      |         |        |              |               |               |                  |                    |
| D5470                          | <i>A2 Rev A 5 16/11/03</i>                                    |                      |         |        |              |               |               |                  | <i>PR 16/11/03</i> |
| 100                            | FLOW WATER JET                                                | 0.01                 |         |        |              |               |               |                  |                    |
| <b>*100*</b>                   |                                                               |                      |         |        |              |               |               |                  |                    |
| Waterjet                       | <b>Memo</b>                                                   | 0.01                 |         |        |              |               |               |                  |                    |
| FLOW CNC Waterjet              | 1-Cut as per Dwg<br>Dwg Rev: <i>A2</i><br>Prog Rev: <i>A2</i> |                      |         |        |              |               |               |                  |                    |
|                                | 2-Deburr if necessary                                         |                      |         |        |              |               |               |                  |                    |
| 110                            | QC2- Inspect parts off machine FAI/FAIB                       | 0.00                 |         |        |              |               |               |                  |                    |
| <b>*110*</b>                   |                                                               |                      |         |        |              |               |               |                  |                    |
| QC                             | <b>Memo</b>                                                   | 0.01                 |         |        |              |               |               |                  |                    |
| Quality Control                |                                                               |                      |         |        |              |               |               |                  |                    |

*4 PR 16/11/03*

# Work Order ID 152658

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**\*152658\***

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Item ID: D5470-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: PRELIM Stop **\*NS2\***  
Item Name: Spacepod Floor Shim  
Start Date: 11/3/2016 Start Qty: 4.00 **\*4\*** Cust Item ID:  
Required Date: 11/3/2016 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                        | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp    |
|--------------------------------|-------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 120                            | QC8- Inspect parts - second check               | 0.00                 |         |        |              | 4             |               |                  | DAS<br>38<br>9-89 |
| <b>*120*</b>                   | Memo                                            | 0.01                 |         |        |              |               |               |                  |                   |
| QC                             |                                                 |                      |         |        |              |               |               |                  |                   |
| Quality Control                |                                                 |                      |         |        |              |               |               |                  | NOV 08 2016       |
| 130                            | Identify as per dwg & Stock Location: <u>St</u> | 0.00                 |         |        |              | 4             |               |                  | DAS<br>6<br>9-89  |
| <b>*130*</b>                   | Memo                                            | 0.01                 |         |        |              |               |               |                  |                   |
| Packaging                      |                                                 |                      |         |        |              |               |               |                  |                   |
| Packaging                      |                                                 |                      |         |        |              |               |               |                  | NOV 08 2016       |
| 140                            | QC21- Final Inspection - Work Order Release     | 0.00                 |         |        |              |               |               |                  | 16/11/9           |
| <b>*140*</b>                   | Memo                                            | 0.07                 |         |        |              |               |               |                  |                   |
| QC                             |                                                 |                      |         |        |              |               |               |                  |                   |
| Quality Control                |                                                 |                      |         |        |              |               |               |                  |                   |

**POSITIVE RECALL**

EFFECTIVE 16/11/3 AUTH Em  
RELEASED DAS DATE 16/11/08  
16  
9-89

inspector to Rev A Dwg.

16-11-08

# Picklist Print

Thursday, November 03, 2016 10:48:44 AM

Page 1

Work Order ID: 152658

**\*152658\***

Parent Item: D5470-1

**\*D5470-1\***

Parent Item Name: Spacepod Floor Shim

Start Date: 11/3/2016

Required Date: 11/3/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.11.03 NEW ISSUE DD VERF:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MLEXS.125-F6006-02              |                        | Purchased     |             |                     | No               |                 | sf                 | 2,380.000      |             | 23.24211     |               |                |        |
| <b>*MI FXS 125-F6006-02*</b>    |                        |               |             |                     |                  |                 |                    |                | <b>**</b>   |              |               | PR 16/11/03    |        |
| GE PLASTICS LEXAN SHEET(BLACK)  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

Location

Loc Qty

Loc Code

Thermo

2380

m128887

2380

24



|                                             |  |                     |         |
|---------------------------------------------|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                   |  | <b>Work Order:</b>  | 152658  |
| <b>Description:</b> Spacepad Floor Shim     |  | <b>Part Number:</b> | D5470-1 |
| <b>Inspection Dwg:</b> D5470 <b>Rev:</b> A2 |  | Page 1 of 1         |         |

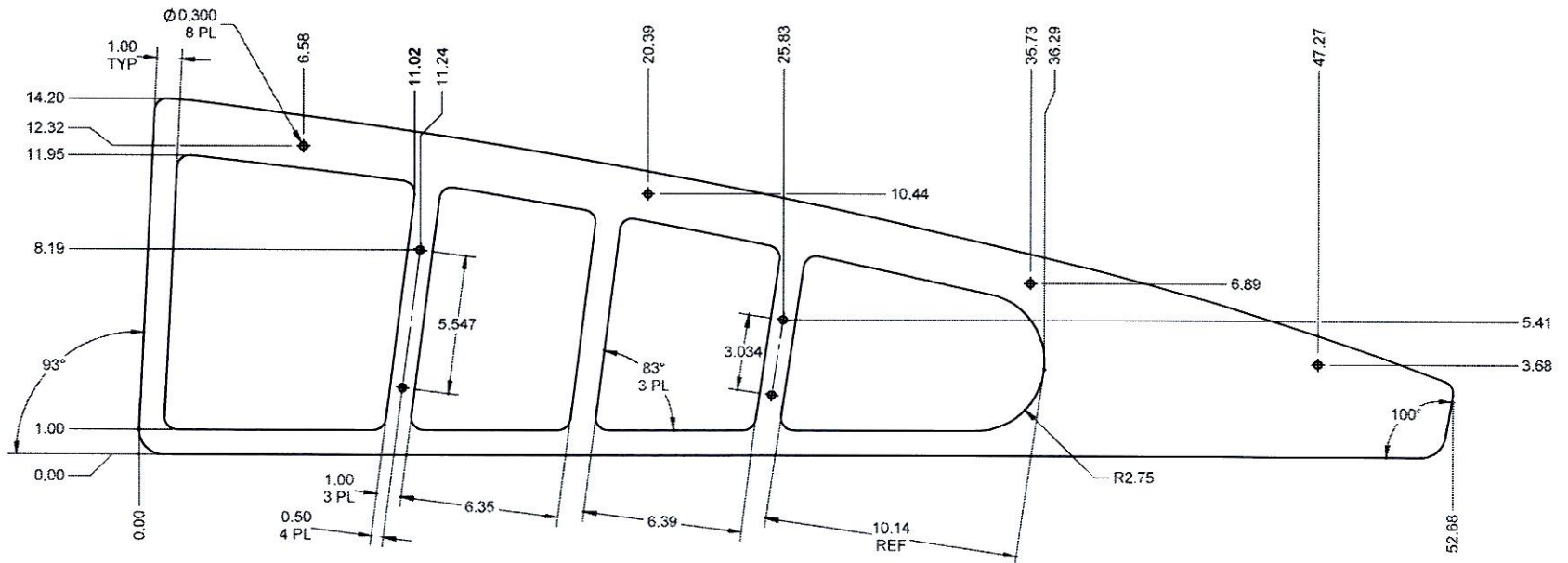
### INSPECTION SHEET

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 0.300             | +0.006 -0.001 | 0.303            | ✓      |        | Dc-02                |          |
| 0.50              | ±.030         | 0.501            | ✓      |        | Tape                 |          |
| 1.00              | ±.030         | 1.006            | ✓      |        |                      |          |
| 5.547             | ±.010         | 5.553            | ✓      |        |                      |          |
| 6.35              | ±.030         | 6.352            | ✓      |        |                      |          |
| 6.39              | ±.030         | 6.393            | ✓      |        |                      |          |
| 3.034             | ±.010         | 3.039            | ✓      |        |                      |          |
| 10.14             | ±.030         | 10.15            | ✓      |        |                      |          |
| 1.00              | ±.030         | 1.005            | ✓      |        |                      |          |
| 8.19              | ±.030         | 8.19             | ✓      |        |                      |          |
| 11.95             | ±.030         | 11.95            | ✓      |        |                      |          |
| 12.32             | ±.030         | 12.32            | ✓      |        |                      |          |
| 14.20             | ±.030         | 14.20            | ✓      |        |                      |          |
| 1.00              | ±.030         | 1.006            | ✓      |        |                      |          |
| 6.50              | ±.030         | 6.50             | ✓      |        |                      |          |
| 11.02             | ±.030         | 11.02            | ✓      |        |                      |          |
| 11.24             | ±.030         | 11.24            | ✓      |        |                      |          |
| 20.39             | ±.030         | 20.39            | ✓      |        |                      |          |
| 25.83             | ±.030         | 25.83            | ✓      |        |                      |          |
| 35.73             | ±.030         | 35.73            | ✓      |        |                      |          |
| 36.29             | ±.030         | 36.29            | ✓      |        |                      |          |
| 47.27             | ±.030         | 47.27            | ✓      |        |                      |          |
| 52.68             | ±.030         | 52.68            | ✓      |        |                      |          |
| 10.44             | ±.030         | 10.44            | ✓      |        |                      |          |
| 6.89              | ±.030         | 6.89             | ✓      |        |                      |          |
| 5.41              | ±.030         | 5.41             | ✓      |        |                      |          |
| 3.68              | ±.030         | 3.68             | ✓      |        |                      |          |
| 0.125             | ±.010         | 0.130            | ✓      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                        |                                                         |                      |
|------------------------|---------------------------------------------------------|----------------------|
| <b>Measured by:</b> PR | <b>Checked by:</b> <span style="color: blue;">38</span> | <b>QC Inspector:</b> |
| <b>Date:</b> 16/11/03  | <b>Date:</b> <span style="color: blue;">9-08</span>     | <b>Date:</b>         |

|                                                |              |
|------------------------------------------------|--------------|
| <b>Engineering Approval:</b><br>(If necessary) | <b>Date:</b> |
|------------------------------------------------|--------------|

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| B   | 14.07.31 | New Issue | KJ         |          |



**D5470-1-1 SPACEPOD FLOOR SHIM**

**SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 152658  
Jm 16/11/3**

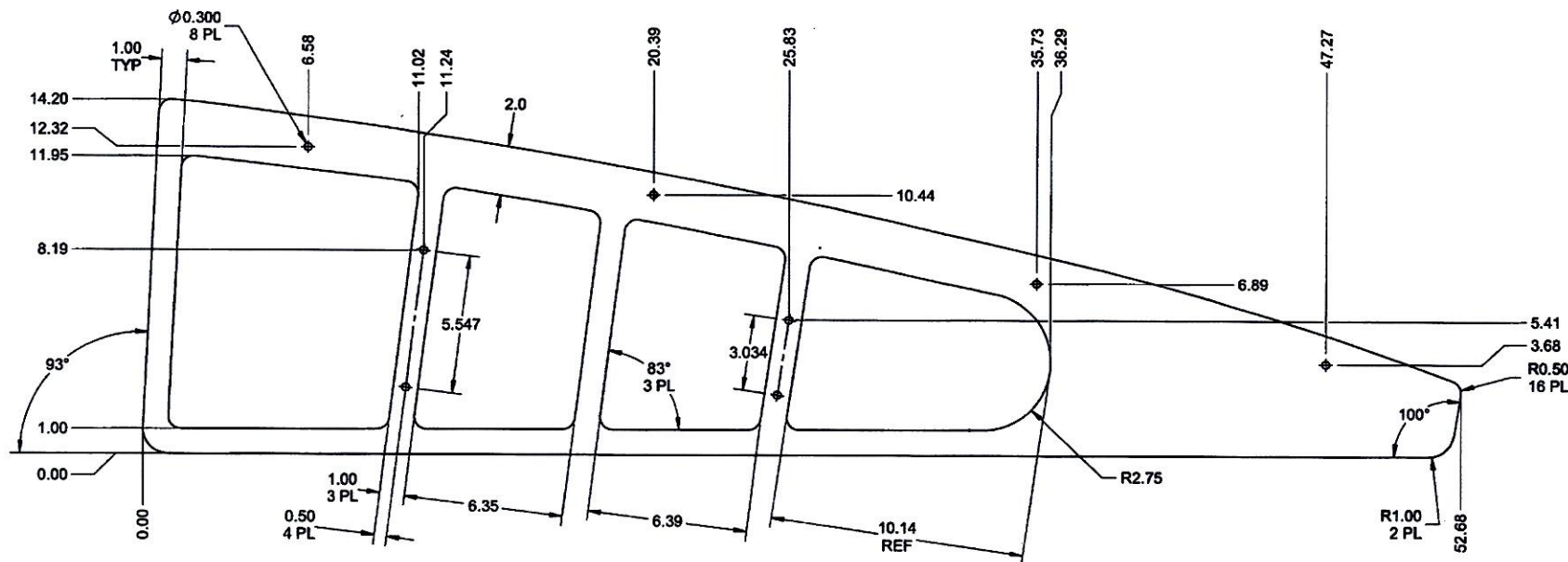
**PRELIMINARY ISSUE**

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL SHEET 0.125 THICK  
REF DART SPEC M-DELIN-S.125  
OR GE PLASTICS BLACK, GREY OR CLEAR LEXAN SHEET 0.125 THICK  
REF DART SPEC MLEXX.125-9034-01/-02/-04/-07/-08
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.53 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE D5470-1-REVA.DXF

**UNAPPROVED**

| A NEW ISSUE |             | ML                                                                                                                                                                                                                                                                             | 16.11.01     |
|-------------|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| REV.        | DESCRIPTION | BY                                                                                                                                                                                                                                                                             | DATE         |
| DESIGN      | ML          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                       |              |
| DRAWN       | ML          |                                                                                                                                                                                                                                                                                |              |
| CHECKED     | AJS         | DRAWING NO.                                                                                                                                                                                                                                                                    | REV. A2      |
| MFG. APPR.  |             | D5470                                                                                                                                                                                                                                                                          | SHEET 1 OF 1 |
| APPROVED    |             | TITLE                                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.    |             | SPACEPOD FLOOR SHIM                                                                                                                                                                                                                                                            | NTS          |
| DATE        | 16.11.01    | COPYRIGHT © 2016 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |



**D5470-1 SPACEPOD FLOOR SHIM**

**RELEASED**

2016 NOV 09  
ECN R-642

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL SHEET 0.125 THICK  
REF DART SPEC M-DELRIN-S.125  
OR GE PLASTICS BLACK, GREY OR CLEAR LEXAN SHEET 0.125 THCK  
REF DART SPEC MLEXS.125-9034-01/-02/-04/-07/-08
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 1.53 lbs
- 8) ALL NON DIMENSIONED FEATURES PER CAD FILE D5470-1-REVA.DXF

| A NEW ISSUE |             | ML | 16.11.01 |
|-------------|-------------|----|----------|
| REV.        | DESCRIPTION | BY | DATE     |
| DESIGN      | ML          |    |          |
| DRAWN       | MB          |    |          |
| CHECKED     | CP          |    |          |
| MFG. APPR.  | JLM         |    |          |
| APPROVED    | WM          |    |          |
| DE APPR.    | DS          |    |          |
| DATE        | 16.11.01    |    |          |

|                                                          |              |
|----------------------------------------------------------|--------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |              |
| DRAWING NO.<br><b>D5470</b>                              | REV. A       |
| TITLE<br><b>SPACEPOD FLOOR SHIM</b>                      | SHEET 1 OF 1 |
| SCALE<br>NTS                                             |              |

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